

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018443**Date Inspected:** 23-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

On this date, the QA Inspector observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

SAS-EB Traveler**Fixed Stairs Section**

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Jose Rodriguez (WID # 3031), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit Frame assemblies, identified as 10-A237, 11-B237, 3-A217, 4-A218, 5-A223 and 6-A224. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

Lower Truss Section

The QA Inspector observed WMI production personnel Mr. Raymundo Anaya (WID # 3196) and Mr. Cesar Canales performing fitting and Flux Core Arc welding (FCAW) activities on the Elevating Platform, for the Lower Truss Section. The QA Inspector observed that the fitting and tacking activities were being performed on the Stair Risers, piece marks identified as C270F, to Stair Supports, piece marks identified as A270F and B270F. The QA

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Inspector observed that the fitting and tacking activities were also being performed on what appeared to be various plate material fillet and flare groove welds. In addition, the QA Inspector observed Mr. Anaya and Mr. Canales performing fitting and tacking activities on the Platform Balcony Assembly, for the Lower Truss Section. The QA Inspector observed the activities being performed on channel and Tube Steel (TS) material.

See attached picture below.

E2/E3-EB Traveler

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059), continuing to perform Flux Core Arc Welding (FCAW) welding activities on the intermediate and diagonal bracing Tube Steel (TS) material. The QA Inspector observed that the FCAW being performed by Mr. Jimenez appeared to be for the Frame Assembly identified as 9-A332 and 10-B332, per the shop drawings. The QA Inspector observed that the weld joints appeared to be designated as 6mm fillet and flush flare groove welds and that Mr. Jimenez was performing the FCAW in the flat (1G) and vertical (3F) positions, throughout the shift. In addition to the activities being performed by Mr. Jimenez, the QA Inspector observed WMI Production fitter Mr. Cesar Canales, performing layout and fitting activities on tube steel material, for the above mentioned Frame Assemblies. The QA Inspector observed that Mr. Canales was performing the activities on the intermediate and diagonal bracing for the Frame Assemblies, prior to tack welding.

See attached picture below.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities and QC Inspector Dominguez explained that approved Welding Procedure Specifications (WPS's) were being utilized. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings, were located near each work station, where the above mentioned welding and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.



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Summary of Conversations:

On this date, the QA Inspector observed Smith Emery (SE) QC Inspector Ramiro Zavalza performing what appeared to be final Visual Testing (VT) on the previously completed Fillet and Flare groove welds on the SAS-EB Lower Truss Assembly. After observing these activities, the QA Inspector then spoke with Lead SE QC Inspector Ruben Dominguez regarding the Qualifications and Certifications of Mr. Zavalza. Mr. Dominguez explained that Mr. Zavalza was currently certified as an AWS Certified Welding Inspector (CWI) and had been previously submitted to Caltrans and approved to perform inspections on the project. After conversation with Mr. Dominguez, the QA Inspector reviewed WMI WQCP current Rev. # 6 and was not able to locate Mr. Zavalaz's current Certification as a CWI. The QA Inspector then reviewed previous revisions of WMI WQCP and was still unable to locate Mr. Zavalza.

The QA Inspector then spoke with WMI Director of Quality Assurance, Mr. Curt Bell. The QA Inspector informed Mr. Bell that the QA Inspector was unable to locate the Qualifications and Certifications of Mr. Zavalza and that per Special Provisions Section 8.3 Welding "The QC Inspector shall be responsible for quality control acceptance or rejection of materials and workmanship and shall be currently certified as an AWS Certified Welding Inspector (CWI) in conformance with the requirements in AWS QC1, "Standard and Guide for Certification of Welding Inspectors". The QA Inspector then informed Mr. Bell that Mr. Zavalza's qualifications and certifications should be formally submitted to Caltrans for review, prior to performing final inspections on the project. Mr. Bell then explained that he will investigate this matter further. Structural Materials Representative, Kit Guest was informed of this issue.

Near the end of the shift, the QA Inspector still observed Mr. Zavalza performing what appeared to be final VT on the previously completed Fillet and Flare Groove welds, on the SAS-EB Traveler Assemblies.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
